

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024651**Date Inspected:** 24-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Service Platform repairs at Pier 7
- 2) North Tower field splice welding

1) The QAI went to ABF facilities at Pier 7 to observe repair welding of service platform #5 and service platform #6. The QAI met with the Quality Control Inspector (QCI) Mike Johnson and made general observations of the service platforms as they were presented. The QAI and the QCI noted that the primary members for repair have been welded, the QCI informed the QAI that this welding was performed on 6.22.2011. The QAI noted that there appears to be 2 unwelded connection pieces for service platform #5. The QAI asked the QCI when this welding would be done. The QAI was informed that the primary members needed to be re-fit and bolted before the remaining pieces could be fit-in and welded. The QCI remarked that he was not aware of when this work would be performed. See the attached photos.

2) The QAI observed ABF personnel welding field splice closure plates inside the North tower shaft at field splice #3. The QAI observed Xiao Jian Wan, ID 9677, at the North upper plate (weld N165) and Salvador Sandoval, ID 2202, at the North-East upper plate (weld NE165). The QAI noted that both welders are making vertical fillet welds (3F) using self shielded flux cored arc welding (FCAW-S) with 1.8mm diameter E71T-8-H16 electrode (NR-232). The QAI observed that QCI Steve Jensen is monitoring this welding. The QAI was informed that

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welding procedure specification ABF-WPS-D15-F2200-3 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters, with the exception of travel speed, and noted that they appeared to be conforming to the WPS requirements. The QAI noted that this welding was in progress at the end of the shift. See the attached photos.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed general observations and status of work to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
